



Dart Aerospace Ltd.
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RB072610-H-B-B01

Job Sheet 198533



Part No: RB072610-H-B-B01

Job Qty: 2 pcs

Part Name: Weldment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/30/19

Job Tracking No:

Due Date: 9/9/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB072610-H-B Rev.1 IPP Rev. A 19.01.23 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
110	Large Fab - Welded Assy-1	2 pcs	9/9/19	9/9/19	0.00	2.00	Large Fab - 1		EL
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
115	QC 9	2 pcs	9/9/19	9/9/19	0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		DAS
							QC 9 - 43		43
							QC 9 - 50		9-89
							QC 9 - 9		
120	QC 5	2 pcs	9/9/19	9/9/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		DAS
							QC 5 - 49		43
							QC 5 - 51		9-89
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		



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Container No: S211963



Part: RB072610-H-B-B01

Job No: 198533

Serial No/Batch: S211963

Revision: 1

Inspector:

Exp Date:

Instructions:

Date: 09/08/19

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				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
130 Powdercoat - 13 Yellow - B4B 2 pcs	9/9/19	0.00 0.20	Powdercoat - 1 - B4B		
			Powdercoat - 2 - B4B		
			Powdercoat - 3 - B4B		
			Powdercoat - 4 - B4B		
140 QC 3 2 pcs	9/9/19	0.00 0.00	QC 3 - 10		
			QC 3 - 13		
			QC 3 - 15		
			QC 3 - 17		
			QC 3 - 18		
			QC 3 - 2		
			QC 3 - 28		
			QC 3 - 3		
			QC 3 - 30		
			QC 3 - 34		
			QC 3 - 36		
			QC 3 - 41		
			QC 3 - 51		
			QC 3 - 58		
			QC 3 - 59		
			QC 3 - 68		
			QC 3 - 9		
			QC 3 - 40		
			QC 3 - 19		
			QC 3 - 43		
			QC 3 - 24		
			QC 3 - 61		
			QC 3 - 81		
180 Packaging 3-1 - Stock - B4B 2 pcs	9/9/19	0.00 0.00	Packaging 3 - 1 - B4B		
			Packaging 3 - 2 - B4B		
			Packaging 3 - 3 - B4B		
			Packaging 3 - 4 - B4B		
			Packaging 3 - 5 - B4B		
			Packaging 3 - 6 - B4B		
			Packaging 3 - 7 - B4B		
			Packaging 3 - 8 - B4B		
			Packaging 3 - 9 - B4B		
			Packaging 3 - 10 - B4B		
			Packaging 3 - 11 - B4B		
			Packaging 3 - 12 - B4B		
			Packaging 3 - 13 - B4B		
			Packaging 3 - 14 - B4B		
			Packaging 3 - 15 - B4B		
			Packaging 3 - 16 - B4B		
			Packaging 3 - 17 - B4B		
			Packaging 3 - 18 - B4B		
			Packaging 3 - 19 - B4B		
			Packaging 3 - 20 - B4B		
			Packaging 3 - 21 - B4B		
			Packaging 3 - 22 - B4B		
			Packaging 3 - 23 - B4B		
			Packaging 3 - 24 - B4B		
			Packaging 3 - 25 - B4B		
			Packaging 3 - 26 - B4B		
			Packaging 3 - 27 - B4B		

Bk 14-9-11

DAS
SEP 11 2019 40
9-89

				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	2 pcs	9/9/19	0.00 0.00	QC 21 - SA - 21	SEP 12 2019
				QC 21 - SA - 70	

Part Op 110 - 1-Weld as per DWG. ***Ensure hole alignment**
 Descriptions: 115 - QC9- Inspect visual per QSI004- Fusion Welds
 120 - QC5- Inspect part completeness to step on W/O
 130 - Powdercoat13 - Yellow #13538 - START TIME: 9:55 OVEN TEMPERATURE: 320° FINISH TIME: 10:25
 140 - 1- Inspect Part Finish 2-Ink stamp P/N as per drawing.
 180 - Identify as per dwg & Stock Location:
 190 - QC21- Final Inspection - Work Order Release

DAS
 21
 9-89
 SEP 12 2019

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
RB072610-H-B-B03	Tube	2 pcs (1 ea)	110-Large Fab - Welded Assy-1	5177361
RB072610-H-B-B05	Tab	4 pcs (2 ea)	110-Large Fab - Welded Assy-1	5177365
RB072610-H-B-B07	Front	2 pcs (1 ea)	110-Large Fab - Welded Assy-1	3196735
RB072610-H-B-B09	Back	2 pcs (1 ea)	110-Large Fab - Welded Assy-1	5211499

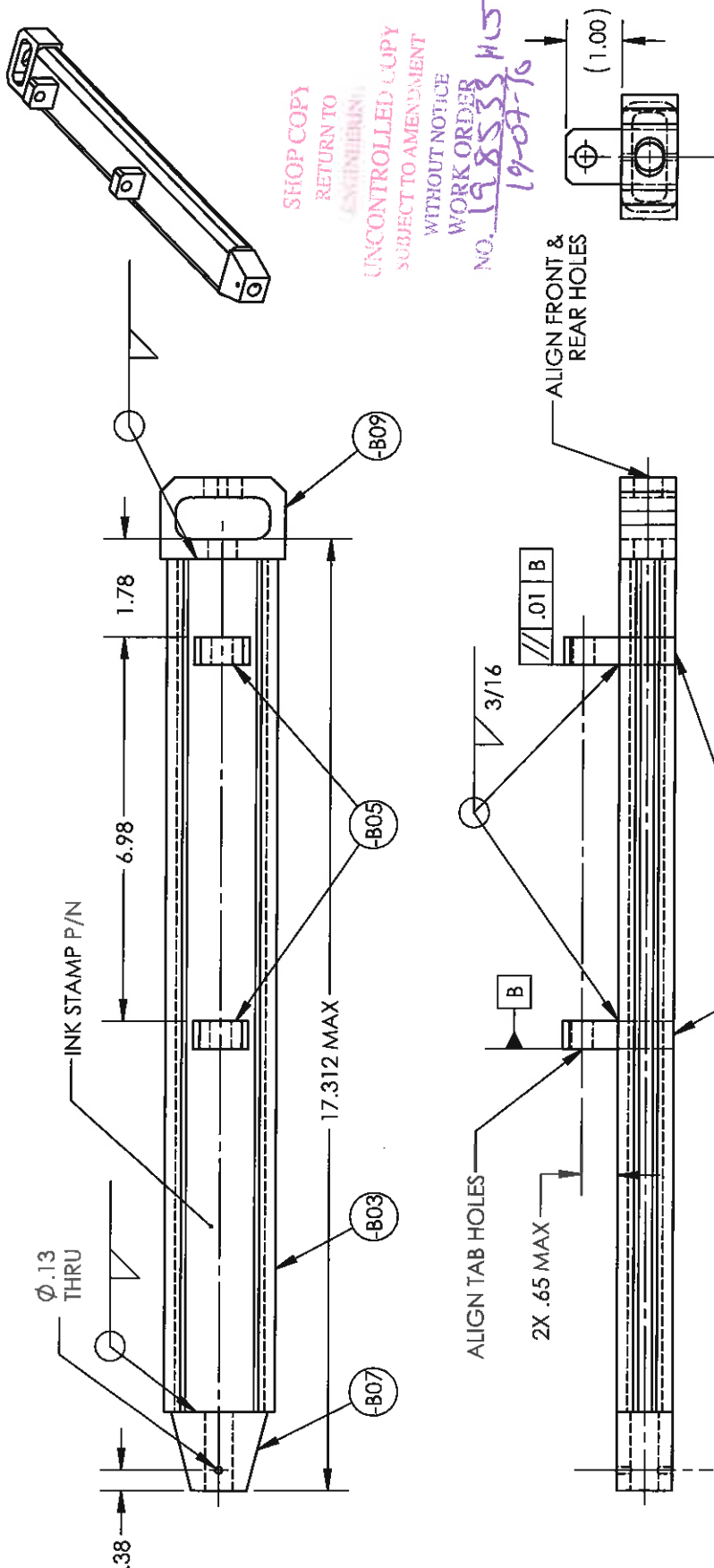
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Welded Assy-1	RB072610-H-B-B03	2	4	0
	RB072610-H-B-B05	4	4	0
	RB072610-H-B-B07	2	4	0
	RB072610-H-B-B09	2	0	0

Part Specifications	
Specifications could not be found.	

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REVISIONS				DESCRIPTION	
REV	ECR	DATE	INITIAL	APPROVED	
1	15-0110	5/18/2015	RJC	JAG	-B01 CH'D FINISH WAS FORREST T-5920 S9 YELLOW RIBBON IS POWDER COAT YELLOW FED # 13538.



SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 198533 HCS
19-07-16



SKID TUBE ATTACHMENT

TITLE	REV
SKID TUBE ATTACHMENT	1
DWG NO.	
MAT'L	
DRAWN BY: PERRITT	
APPROVED: <i>D. Med</i>	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
XXX $\pm .005$	HEAT TREAT
XX $\pm .01$	FINISH
X $\pm .1$	POWDER COAT YELLOW
	SPEC
	FED #13538
	USED ON MODEL
	BELL 206L, 407, & 427
SCALE 1:3	DATE 3/9/2011
	SHEET 2 OF 7

(-B01)

WELDMENT

Entered:

Date:

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only

Job:

Part No.

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date :

Sequence #:

QTY Affected :

MRB (QSI042)

Description Work Order Deviation

Disposition

Completed By

Lead hand / Supervisor

QC / QA Coordinator

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced ☐
Bending ☐
Crushing ☐
Cracks ☐
Crimp/Kink/Ripple/Wave/Twist ☐
Marks/Chatter ☐
Mislabeled ☐
Contamination ☐
Misaligned/off center ☐
BOM/Route ☐
Broken/Damage/Defect ☐
Incomplete/Unclear Instructions ☐
Drill Holes ☐
Fit/Function ☐

Power Loss/Surge ☐
Folio/Program ☐
Grain Direction ☐
Weld ☐
Wrong Stock Pulled ☐
Out of Sequence ☐
Off-set/Set-up ☐

Positioned Wrong ☐
Outside Tolerance ☐
Drawing ☐
Finish ☐
Part Lost/Missing ☐
Misread ☐

Other/Details: